

Work Order ID 139280

Thursday, November 19, 2015 10:22:37 AM

139280

Page 1

Item ID: D350-588-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Door Assembly

Start Date: 11/19/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/18/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2445/D350-588	Rev D/D
DSI9690	A

100

Document Control

0.00

DAS
6
8-89

MAR 11 2016

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

DAS
28
9-89

MAR 14 2016

110

PURCHASING

0.00

110

Purchasing

Memo

0.00

Purchasing

Issue P/O: 30535

Description: D2445 Baggage Door

Supplier: Delastek

Ship to Delastek (1) D0588-041 label

Certification of Conformity and process sheet from Delastek is required.

16.02.24

NOV 20 2015

MAR 09 2016

DAS
13
9-89

re-work

Work Order ID 139280

Thursday, November 19, 2015 10:22:37 AM

139280

Page 2

Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft Door Assembly

Stop ***NS2***

Start Date: 11/19/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/18/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.00							
Packaging	Ensure Certificate of Conformity & Process Sheet are attached								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							
Quality Control	Inspect as per Dwg D2445. Audit process sheet.								
140	Small Fab	0.00							
140									
Small Fab	Memo	0.02							
Small Fab	Assemble all of the above parts as per Dwg D350-588								

~~1X SP/6-02-17~~
1X SP/6-03-09

~~① 160224~~ DAS 9 9-89
① 160310 DAS 9 9-89

xl _____ DAS 07 9-89
16/03/10

Work Order ID 139280

Thursday, November 19, 2015 10:22:37 AM

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Page 3

Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 11/19/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/18/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

① 16-03-10

DAS

9

9-89

155

Pick Kit

0.00

155

Packaging

Memo

0.00

Packaging

MAR 14 2016

160

QC4- 100% Inspect kits for completeness

0.00

160

QC

Memo

0.00

Quality Control

DAS

28

9-89

MAR 14 2016

Work Order ID 139280

Thursday, November 19, 2015 10:22:37 AM

139280

Page 4

Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 11/19/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/18/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

Location :FG021

*Sold**1X*DAS
28
9-89DAS
27
9-89

MAR 14 2016

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

*16/1/14**ML5*

MAR 14 2016

Picklist Print

Thursday, November 19, 2015 10:22:35 AM

Page 1

Work Order ID: 139280

139280

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/19/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS IPP Rev:Q as
per DSI9414 DD verified by:EC IPP Rev:R add pick kit DD
10.03.29 verified by:EC IPP REV:S 14.04.28 AS PER
DSI9690 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R7		Purchased	No			155	Each	188.0000	2	2			
AN526C1032R7									**				
Screw													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST327		188							
				M128403		188							
AN526C832R8		Purchased	No			155	Each	111.0000	8	8			
AN526C832R8									**				
Screw													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST327		111							
				m129706		100							
				m129764		11							
AN526C832R9		Purchased	No			140	Each	279.0000	8	8			
AN526C832R9									**				
Screw													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST325A		279							
				M131957		79							
				M132823		200							

DAS
6
9-89

DAS
6
9-89

MAR 11 2016

DAS
07
9-89

16/02/24

Picklist Print

Thursday, November 19, 2015 10:22:35 AM

Work Order ID: 139280

139280

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/19/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

D2143

Manufactured No

140 ✓ Each

21.0000

1 1

DAS
07
9-89

D2143

Hinge Bracket

**

16/02/24

Location

Loc Qty

Loc Code

ST003

21

121806

21

1

D2144

Manufactured No

140 ✓ Each

11.0000

1

DAS
07
9-89

D2144

Hinge Doubler

**

16/02/24

Location

Loc Qty

Loc Code

ST002

11

114332

11

1

D2150

Manufactured No

155 Each

24.0000

2

DAS
27
9-89

D2150

Packer Doubler, Hinge

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST003

24

121844

24

2

D2151

Manufactured No

155 Each

15.0000

2

DAS
27
9-89

D2151

Packer Doubler

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST003

15

121825

15

2

D2153

Manufactured No

155 Each

29.0000

1

DAS
27
9-89

D2153

Door Prop

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST362

29

131670

29

140759

MAR 11 2016

Picklist Print

Thursday, November 19, 2015 10:22:36 AM

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/19/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

D2154 Manufactured No 155 Each 31.0000 1 1

D2154

Bracket, Stud

Location

Loc Qty

Loc Code

ST003

31

118894

31

D2237 Manufactured No 155 Each 25.0000 2 2

D2237

Striker Plate

Location

Loc Qty

Loc Code

ST004

25

136090

25

D2445P Purchased No 110 Each 0.0000 1 1

D2445P

Aft Door Assembly

D2461 Manufactured No 155 f 309.9200 7.25 7.25

D2461

Neoprene 'D' Seal (\$Per Foot)

Location

Loc Qty

Loc Code

ST407

309.92

128447

309.92

(D2461-0870) cut (1) at 87.00"

**** per kit****

D2463 Manufactured No 140 f 224.6228 7.25 7.25

D2463

1/2" Seal (\$Per Foot)

Location

Loc Qty

Loc Code

ST638

224.6227526

125469

224.622753

(D2463-0870) cut (1) at 87.00"

**** per kit****

Picklist Print

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Work Order ID: 139280

139280

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/19/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

D2585

Manufactured No

140 ✓ Each

14.0000 2 2

D2585

Latch Clamp

**

DAS
07
9-89

16/02/24

Location

Loc Qty

Loc Code

ST008

14

136264

14

139075

140 ✓ Each

25.0000 2 2

D2586

Manufactured No

D2586

Door Latch

**

DAS
07
9-89

16/02/24

Location

Loc Qty

Loc Code

FG

4

119746

4

ST482

3

129404

3

ST483

18

138048

18

D2589

Manufactured No

155 Each

12.0000 1 1

D2589

Keys, Key Chain

**

DAS
06
9-89

DAS
07
9-89

Location

Loc Qty

Loc Code

ST008

12

132942

12

D2621

Manufactured No

140 ✓ Each

26.0000 2 2

D2621

Latch Plate

**

MAR 11 2016

DAS
07
9-89

16/02/24

Location

Loc Qty

Loc Code

FG

2

88616

2

ST012a

24

127749

24

Picklist Print

Thursday, November 19, 2015 10:22:36 AM

Work Order ID: 139280

139280

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/19/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

D2690-17 Manufactured No

155 Each 15.0000 1 1

D2690-17

Cable

Location

Loc Qty

Loc Code

ST012a

15

112206

6

120107

3

121750

6

MAR 11 2016

DAS
07
9-89

D2857-1 Manufactured No

140 ✓ Each 18.0000 1 1

D2857-1

Hinge Bracket

Location

Loc Qty

Loc Code

FG

5

121829

2

82261

2

91914

1

ST012

13

121829

1

133964

12

16/02/24

D2857-2 Manufactured No

140 ✓ Each 17.0000 1 1

D2857-2

Hinge Bracket

Location

Loc Qty

Loc Code

FG

5

130848

2

78904

3

ST012

12

133903

12

16/02/24

DAS
07
9-89

Picklist Print

Thursday, November 19, 2015 10:22:36 AM

Page 6

Work Order ID: 139280

139280

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/19/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

D2858-1

Manufactured No

155

Each

18.0000

1

1

D2858-1

Hinge Bracket

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

2

77019

2

ST012

16

121400

4

133091

12

D2858-2

Manufactured No

155

Each

8.0000

1

1

D2858-2

Hinge Bracket

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

2

77020

2

ST012

6

121563

6

D5080-041

Manufactured No

155

Each

44.0000

2

2

D5080-041

Striker Plate Assembly

DAS
6
9-89

Location

Loc Qty

Loc Code

prelim

1

115524

1

ST148

43

121798

2

126722

17

128722

24

MAR 1-1 2016

Picklist Print

Thursday, November 19, 2015 10:22:36 AM

Page 7

Work Order ID: 139280

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

139280

D350-588-041

Start Date: 11/19/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

FG-778150-550-ROL

Purchased

No

155

sf

738.0000

1

1.333333

***FG-778150-550-ROL ***

7781 9oz Glass 50x125yd

DAS

6

9-89

DAS

28

9-89

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

Purchased

No

155

Each

3,312.000

12

12

MS20426AD3-4

RIVET

DAS

6

9-89

Location

Loc Qty

Loc Code

CA2

738

M127701

738

Location

Loc Qty

Loc Code

GA

3149

m131697

3149

ST312

163

m127432

163

MS20470AD4-5

Purchased

No

155

Each

678.0000

18

18

MS20470AD4-5

RIVET, UNIVERSAL HEAD

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

GA

657

m128401

645

m128813

12

ST310

21

m128813

21

MAR 11 2016

Thursday, November 19, 2015 10:22:36 AM

Shop Packet Print

Page 7

Picklist Print

Thursday, November 19, 2015 10:22:36 AM

Work Order ID: 139280

139280

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/19/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

140

Each

945.0000

8

8

MS21042L 08

Nut

DAS
07
9-89

16/02/24

Location

Loc Qty

Loc Code

CA, m 133922	101	
m129682	101	
GA	56	
m133134	56	
ST303	718	
m133483	700	
m133523	18	
ST304	70	
m128401	58	
m131317	12	

8

MS21042L08

Purchased

No

155

Each

945.0000

10

10

MS21042L 08

Nut

133922

DAS
27
9-89

11/11/2016

Location

Loc Qty

Loc Code

CA	101	
m129682	101	
GA	56	
m133134	56	
ST303	718	
m133483	700	
m133523	18	
ST304	70	
m128401	58	
m131317	12	

DAS
28
9-89

1133922

Picklist Print

Thursday, November 19, 2015 10:22:36 AM

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139280

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/19/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

140 ✓

Each

515.0000

2

2

MS21042L3

Nut

**

DAS
07
9-89

12/02/21

Location

Loc Qty

Loc Code

FP001

134039

300

M130922

300

GA

88

M131317

88

ST304

127

M133498

127

MS21042L3

Purchased

No

155

Each

515.0000

4

4

MS21042L3

Nut

**

DAS
6
9-89

27
9-89

Location

Loc Qty

Loc Code

FP001

300

M130922

300

GA

88

M131317

88

ST304

127

M133498

127

MS27039-08-11

Purchased

No

155

Each

196.0000

2

2

MS27039-08-11

SCREW

**

133769

DAS
6
9-89

27
9-89

Location

Loc Qty

Loc Code

cck007a

100

m133363

100

ST282

96

m130358

1

m133134

95

DAS
28
9-89

DAS
28
9-89

MAR 11 2016

Picklist Print

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/19/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-15

Purchased

No

140 ✓

Each

887.0000

2

2

MS27039-1-15

Screw

**DAS
07
9-89**

14/02/24

Location

Loc Qty

Loc Code

cck007a

800

m132640

600

m132701

200

GA

51

m127916

51

ST285

36

m127916

10

m130388

1

m132317

25

NAS1149D0363J

Purchased

No

140 ✓

Each

657.0000

2

2

NAS1149D0363J

Washer

**DAS
07
9-89**

14/02/24

Location

Loc Qty

Loc Code

CA

246

m130799

246

GA

236

m130799

236

ST269

175

m126319

7

m128429

2

m131618

1

m132317

10

m132677

42

m133031

113

133932

2

Picklist Print

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Parent Item: D350-588-041

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Parent Item Name: Aft Door Assembly

Start Date: 11/19/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

155

Each

657.0000

2

2

NAS1149D0363J

Washer

134055

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CA

133932
m130799

246

246

GA

m130799

236

236

ST269

m126319

175

7

m128429

2

m131618

1

m132317

10

m132677

42

m133031

113

NAS1149DN832J

Purchased

No

140

Each

1,373.000

8

8

NAS1149DN832J

Washer

DAS
07
9-89

16/02/24

Location

Loc Qty

Loc Code

CA

M129499

84

84

ST270

M129541

1289

M131697

23

1266

Picklist Print

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Work Order ID: 139280

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/19/2015

Required Date: 12/18/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

155

Each

1,373.000

16

16

NAS1149DN832.J

**

Washer

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST270

1289

M129541

23

M131697

1266

DAS
28
9-89

DAS
6
9-89

MAR 11 2016

DAS
27
9-89

⬇

Thursday, November 19, 2015 10:22:36 AM

Shop Packet Print

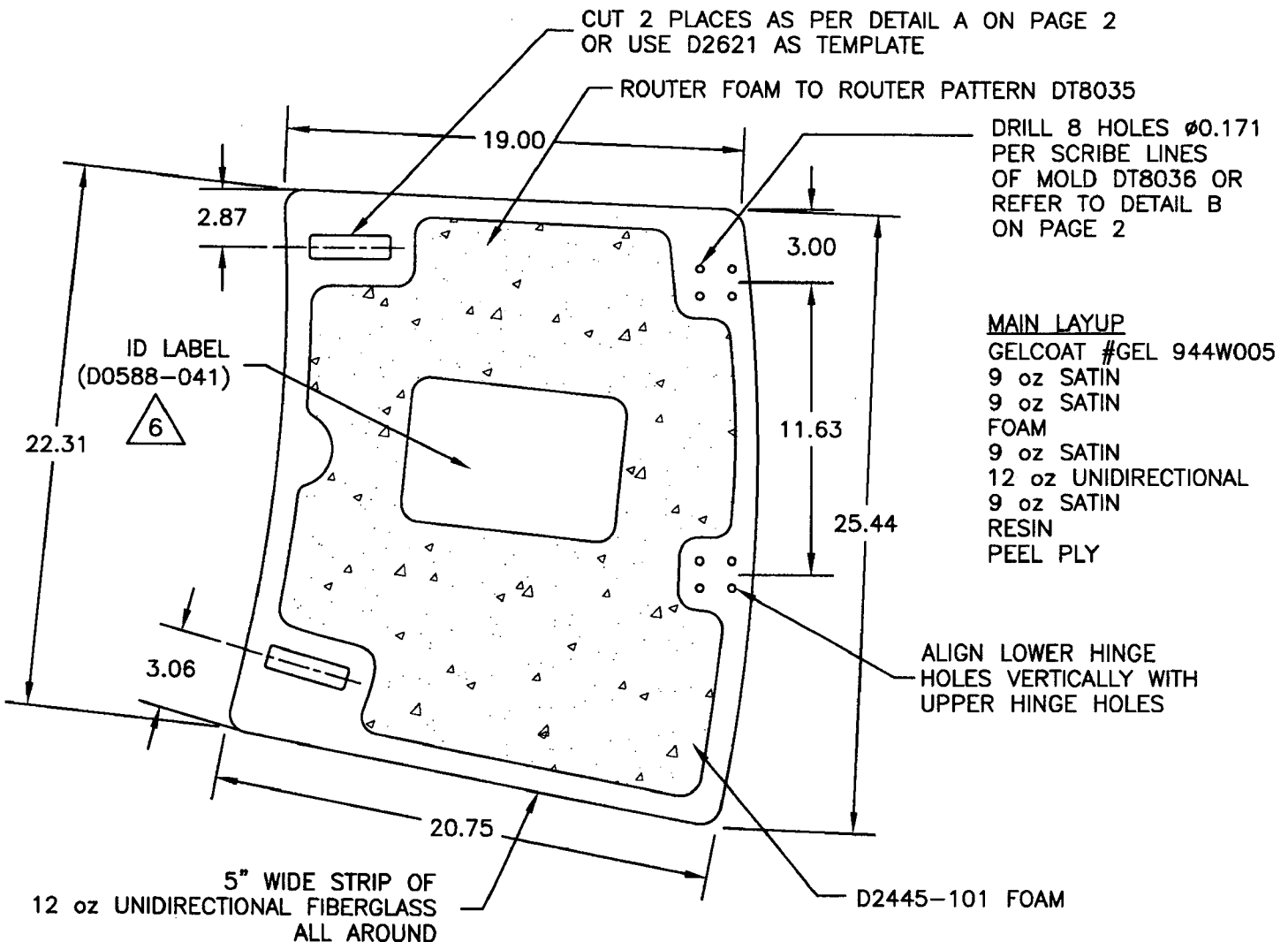
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DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED

06.11.13



NOTES:

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

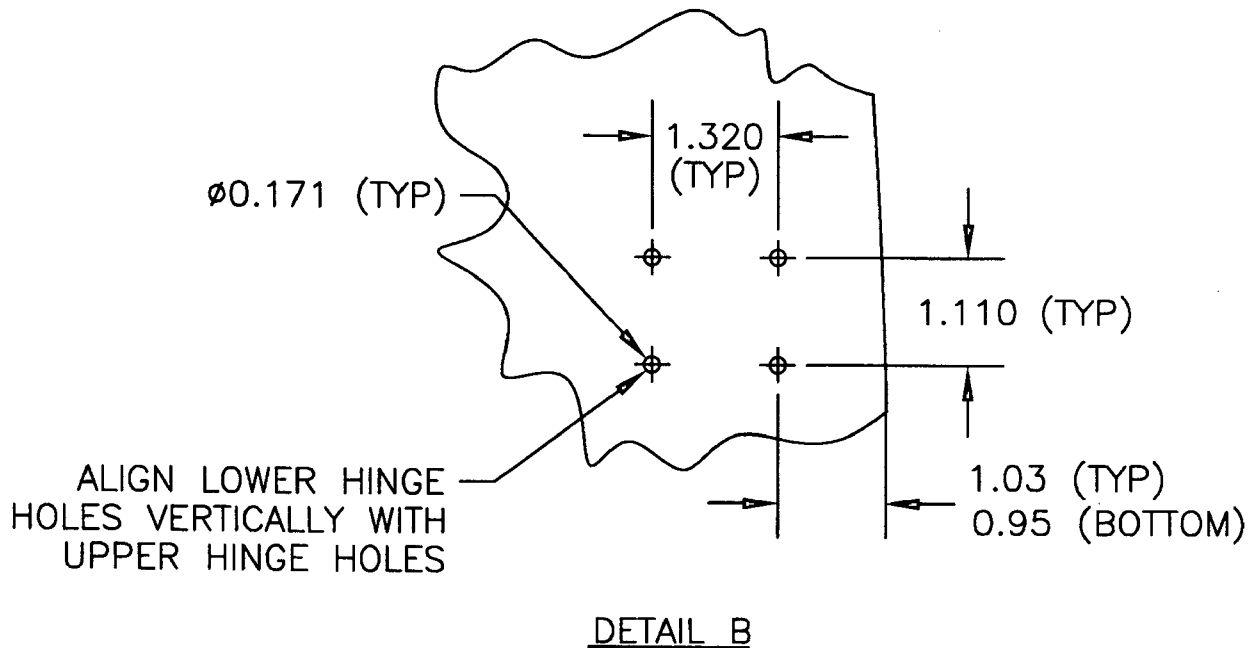
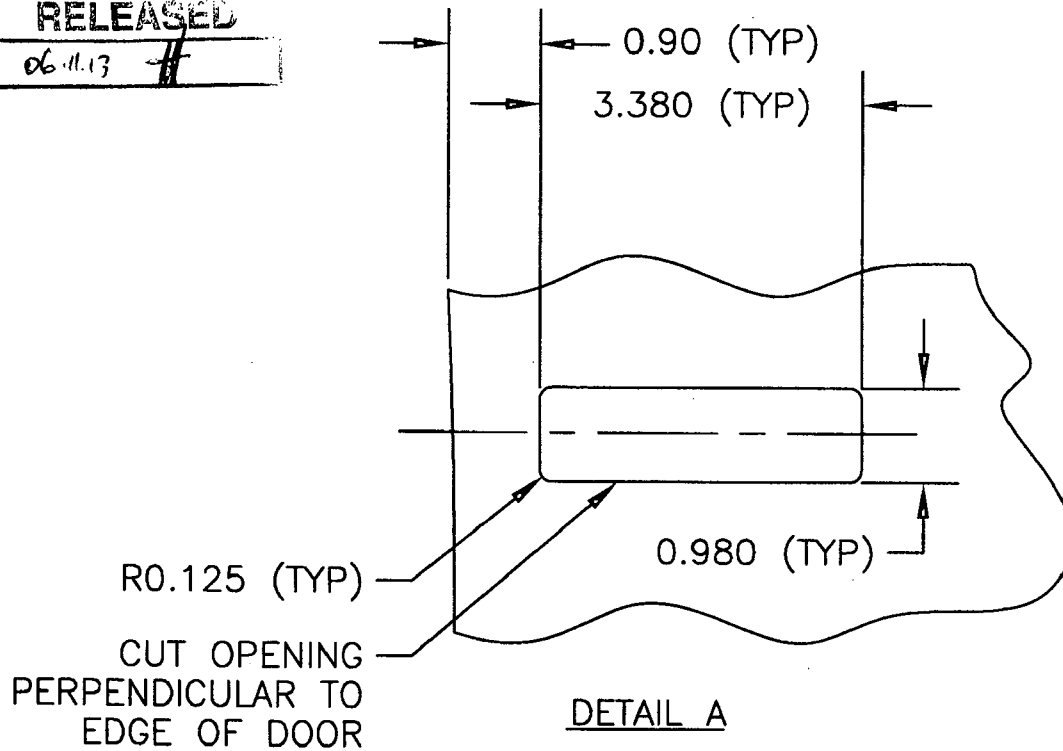
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DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED
06.11.13 *[Signature]*



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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30535**

Purchase Order Date 11/20/2015

PO Print Date 11/20/2015

Page Number 1 of 3

Order From :

VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	450-357-1344 ext303	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	CAD
Ship Via:	FedEx Overnight collect	FOB	Destination-Collect
Ship Acct:			

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments	Promise Date					
	Delivery Comments						
1	D2445P	Aft Door Assembly	12/18/2015		1.00	\$670.00	\$670.00
			Yes		Each		
			12/18/2015				

AS PER DWG D2445 REV. D
B139280

NOTE: AFT DOOR ASSEMBLY TO BE DONE AT DART AEROSPACE

Sp/16-017

Line Total: \$670.00

2	D2445P	Aft Door Assembly	12/18/2015		1.00	\$670.00	\$670.00
			Yes		Each		
			12/18/2015				

AS PER DWG D2445 REV. D
B139281

NOTE: AFT DOOR ASSEMBLY TO BE DONE AT DART AEROSPACE

Line Total: \$670.00

Note:

11/20/2015

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tél.: 450 357-1344

Bon de livraison 23/12/2015

Commande : 2344
Référence : PO #30535/1-2

Client : Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Expédier à
DART AEROSPACE LTD
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7
Tél.: 1 613 632-9577

No item	Description	Qté	Qté livrée	Qté B/O
D2445P ✓	Aft Door Assembly B139280 PO item: 30535/1 Lot: 2015-12-01	1 ✓	_____	_____
D2445P	Aft Door Assembly B139281 PO item: 30535/2 Lot: 2016-01-07	1	_____	_____

CANADIAN CURRENCY

Spille 02-17

Transport : _____
Nb colis : _____
Marchandise reçue : _____

Réf. : _____



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CERTIFICATE of CONFORMITY

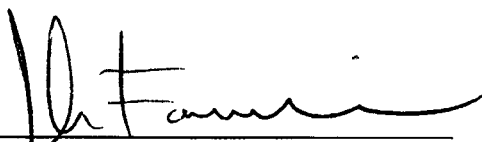
Customer Name: Dart Aerospace.

Customer P/O Number: 30535

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Drawing number</u>	<u>Description</u>	<u>FDC Serial</u>	<u>Lot</u>
1	1	D2445P	D2445 Rev D	Aft Door Assembly B139280	DAE007-001	2015-12-01
2	1	D2445P	D2445 Rev D	Aft Door Assembly B139281	DAE007-004	2016-01-07

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature:


Jules Fournier, BDI, Quality Manager

Date:

2016-02-17.
2015-12-23



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO30535

Purchase Order Date 11/20/2015

PO Print Date 3/9/2016

Page Number 1 of 1

Order From : VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD

1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

Contact Name

Vendor Phone 450-357-1344 ext303

Vendor Fax 450-357-1194

Ship To Contact

Ship To Phone

Ship Method FedEx Overnight collect

Ship Acct

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
8	139281 <i>B</i>	D2445 AFT DOOR ASSEMBLY <i>B</i>	3/9/2016 Yes 3/9/2016	1.00 <i>B/10</i> <i>SP/16-03-9</i>	\$0.00
	RE-WORK			Line Total:	\$0.00
9	139280	D2445 AFT DOOR ASSEMBLY ✓	3/9/2016 Yes 3/9/2016	1.00 <i>SP/16-03-9</i>	\$0.00
	RE-WORK			Line Total:	\$0.00
Outstanding PO Total:					\$0.00

Change Nbr: 4

Change Date: 3/9/2016

Terms & Condition of
Purchasing(Suppliers) and
Procurement Quality Clauses are an
integral part of our AS9100

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tél.: 450 357-1344

Bon de livraison

04/03/2016

Commande : 2374
Référence : PO #30535/1

Client : Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Expédier à

Même

Tél.: 1 613 632-9577

No item	Description	Qté	Qté livrée	Qté B/O
---------	-------------	-----	------------	---------

D2445P

Aft Door Assembly

B140658

PO item : 31001/1

Lot: 2016-01-18

CANADIAN CURRENCY

NO CHARGE : REPAIRS

88 16-03-8

Transport : _____

Nb colis : _____

Marchandise reçue : _____

Réf. : _____



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 30535

Certificate Revision : A

SP 16-03-8.

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Drawing number</u>	<u>Description</u>	<u>FDC Serial</u>	<u>Lot</u>
1	1	D2445P	D2445 Rev D	Aft Door Assembly B139280	DAE007-001	2015-12-01

Part received from Dart for modification by FDC to suite required tolerance for hardware installation. Composite repair process performed as per Dart's QSI 037 Issue 2 Composite Repair Manual.

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: Jules Fournier
Jules Fournier, BDI, Quality Manager

Date: 2016-03-04

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

Work Order ID 139280

139280

Page 1

Thursday, November 19, 2015 10:22:37 AM

Item ID: D350-588-041 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Aft Door Assembly

Start Date: 11/19/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 12/18/2015 Req'd Qty: 1.00 *1*

Customer:

Reference: Run Start *NR1*

Approvals: Process Plan: JK Date: Tooling: Date: Stop *NR2*

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2445/D350-588	Rev D/D
DSI9690	A

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-588-041 CHG003								

MCS MAR 11 2016

110	PURCHASING	0.00							
110									
Purchasing	Memo	0.00							

NOV 20 2015

Issue P/O: 30535
Description: D2445 Baggage Door
Supplier: Delastek
Ship to: Delastek (1) D0588-041 label
Certification of Conformity and process sheet from Delastek is required.

MAR 09 2016

16.02.24

U. ...